

Date: Wednesday, 26/09/2007 1:29:24 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 34900	Part Number	: D34435
Estimate Number	: 10566	Drawing Number	: D3443 REV.B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 26/09/2007 S.O. No. : N/A	Drawing Revision	: B
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 03/10/2007
Previous Run	: 33616	Qty:	8 Um: Each
Written By	: _____		
Checked & Approved By	: _____		
Comment	: A 05.11.14 New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 0.5198 f(s)/Unit Total: 4.1580 f(s)

Inventory

AISI 304 SS seamless tubing .750 OD x 0.120 wall

(M304TR0750W120)

Batch: 111051813

FF 07-09-27

8

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

1-Cut blank 5.97 " long

2-Deburr

FF 07-09-27

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1- Mill to length and drill holes as per dwg D3443

2-Deburr as per dwg D3443

JUL 07-10-03

8

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JUL 07-10-03

8

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 34900

Part Number: D34435

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 07/10/04*

⑧

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *st 93*

*07/10/04*

⑧

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/10/04*

⑧

Job Completion



*07/10/04*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

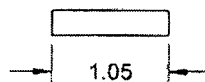
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 3 OF 3
DATE <b>05.12.05</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b>	SCALE <b>1:2</b>

$\phi 0.210^{+0.005}_{-0.010}$



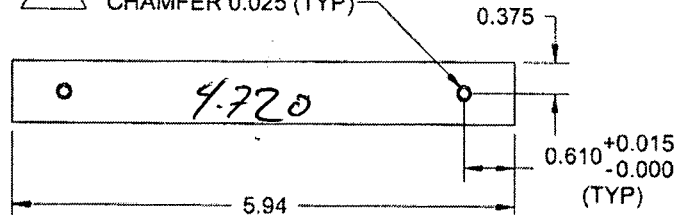
### **D3443-9 PIN**

#### **D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

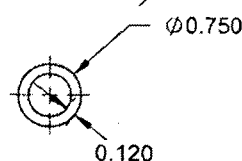


DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)



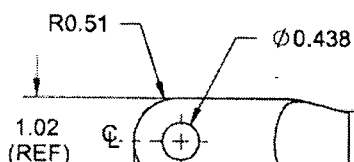
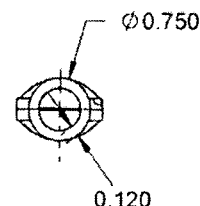
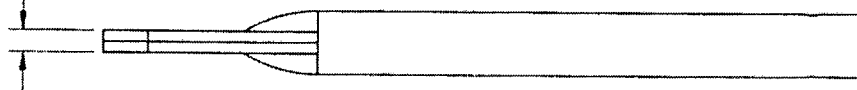
RELEASED

05.12.09

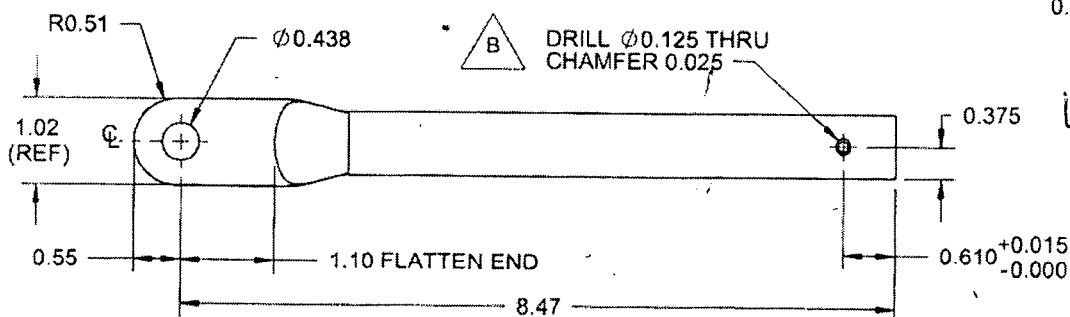


### **D3443-5 TUBING**

$0.260^{+0.000}_{-0.030}$



DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025



### **D3443-7 TUBING**

#### **D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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DART AEROSPACE LTD		Work Order:	34900.
Description: <i>Tubing</i>		Part Number:	D3443-5.
Inspection Dwg: <i>D3443</i> Rev: <i>B</i>		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: 07.10.03.	Date: 07/10/04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	